

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID		
Job Number	: 48209A				
Estimate Number	: 10193				
P.O. Number	:	Part Number	: D2512		
This Issue	: 26/05/2009	S.O. No.	:	Drawing Number	: D2512 REVE
Prsht Rev.	: NC			Project Number	:
First Issue	: / /	Type	: LARGE FAB ASSY	Drawing Revision	: E
Previous Run	: 48202A			Material	:
Written By	: _____	Due Date	: 01/06/2009	Qty:	1
Checked & Approved By	: <u>JUDOR-OS-26</u>			Um:	Each
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC Est Rev:O 08-08-29 revE as per dwg DD verified by:EC Est Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC				

Job Number:



✓	1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Pick:
3/4"x3/4" 304/316 SS tube .065" wall
Batch: M111432

SAN 09-05-27

④

2.0	D31663	Basket Hoop
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Qty	Part Number	Description	Batch
1	D3166-3	Basket Hoop	470

SAD 09-05-27

2

3.0	D2506	Label Plate
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Qty	Part Number	Description	Batch
1	D2506	Label Plate	B44

SY 09/05/28

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 26/05/2009 12:33:56 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 48209A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

D23271

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-1

Bushing

B46325

SY 09/05/27

5.0

D22321

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

B46709

SY 09/05/27

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B46086

SY 09/05/27

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 18.0000 sf(s)/Unit Total: 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

111630 (16)

M 111173(2)

SAD 09-05-27

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

SAD 09-05-27 ①

2-Cut (4) D2236 From D3166-3

SAD 09-05-27 ①

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Dt9436

SY 09/05/28

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Job Number: 48209A

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation: Description :

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

pl 09-05-28

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8 09/05/08

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*Presswash BR 09-05-28
M111472*

✓ 1- Plug holes in D2581 and in D2327-1 bushing prior to powder coating

✓ 2- Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

6:45am

OVEN TEMPERATURE:

400°F

FINISH TIME:

7:15am

2ND COAT:

START TIME:

7:30am

OVEN TEMPERATURE:

400°F

FINISH TIME:

8:00am

HF 09-05-29 (K)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Spray paint: m111301

WW Batch: m111013

FL 09/05/29

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-05-29

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

48209

9/5/29

9/5/29

(K)

SL

W/O:		WORK ORDER CHANGES					
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Drawing Name: 350/212/130 BASKET LID

Job Number: 48209A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/09 [Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

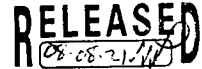
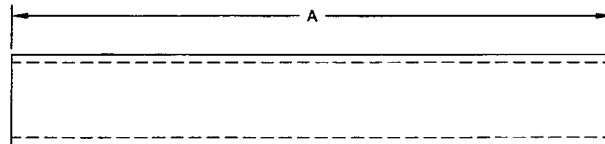
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


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PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	————	25.50	RIB
D2512-3	2	————	95.30	RIB
D2512-5	6	30.84	————	RIB
D2512-7	3	30.63	————	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN 4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.		AJS	08.06.17
D	CHANGE HINGE		CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074		DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE		BW	96.05.24
A	NEW ISSUE		BW	95.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. E D2512 SHEET 1 OF 4 TITLE SCALE BASKET LID ASSEMBLY (350/212) NTS		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.06.17		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: N/A
8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

Dart Aerospace Ltd

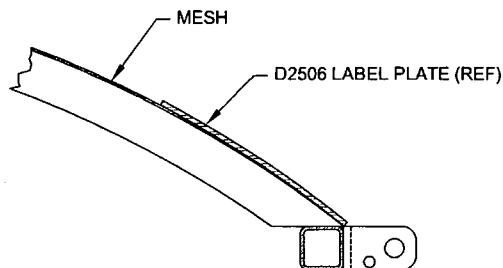
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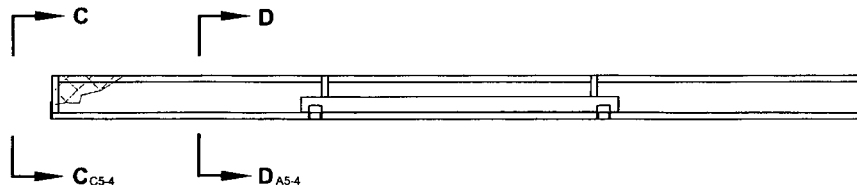
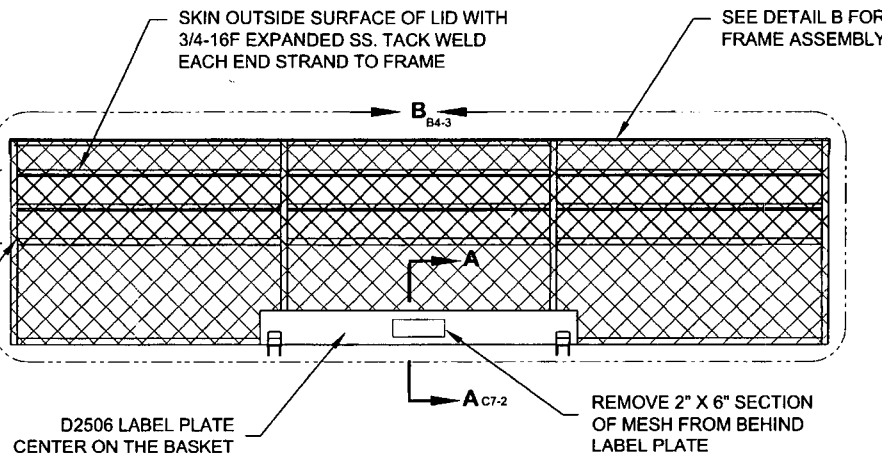
NOTE: Date & initial all entries



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



NO. 1000000
WORK ORDER
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
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SHOP COPY

D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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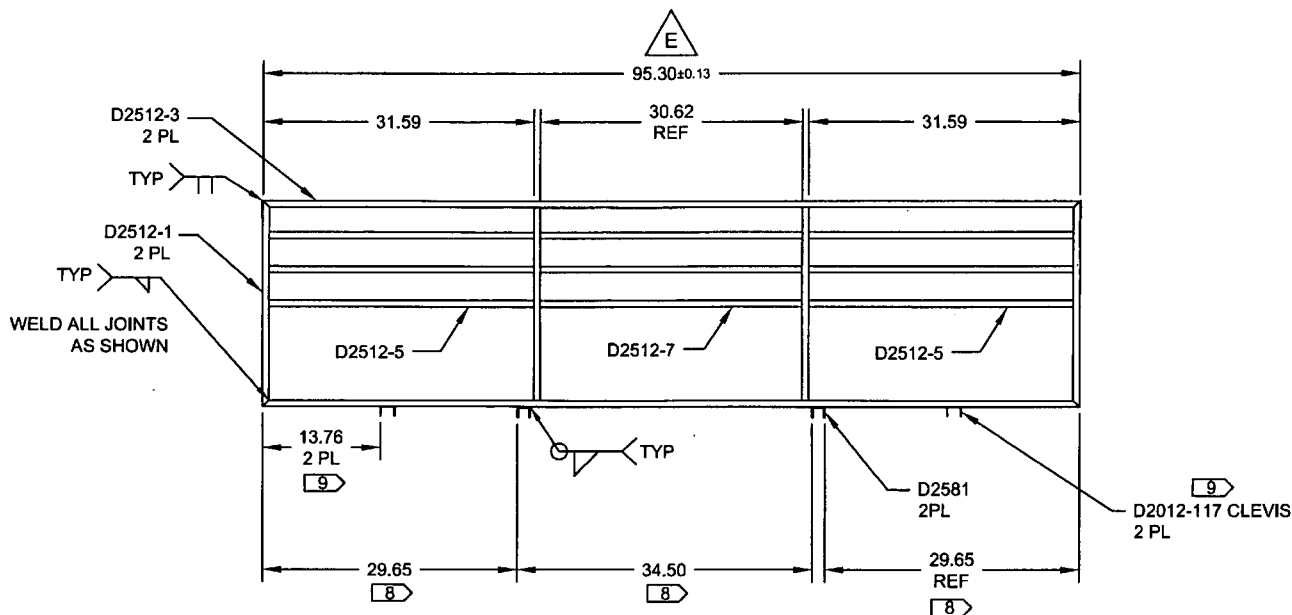
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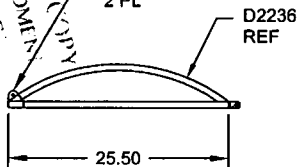
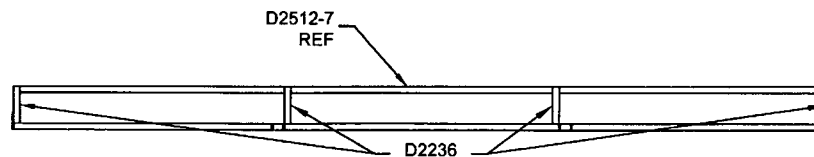
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NOTE: Date & initial all entries



DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



NO WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
D2232-1
2 PL

RELEASED
08-06-17

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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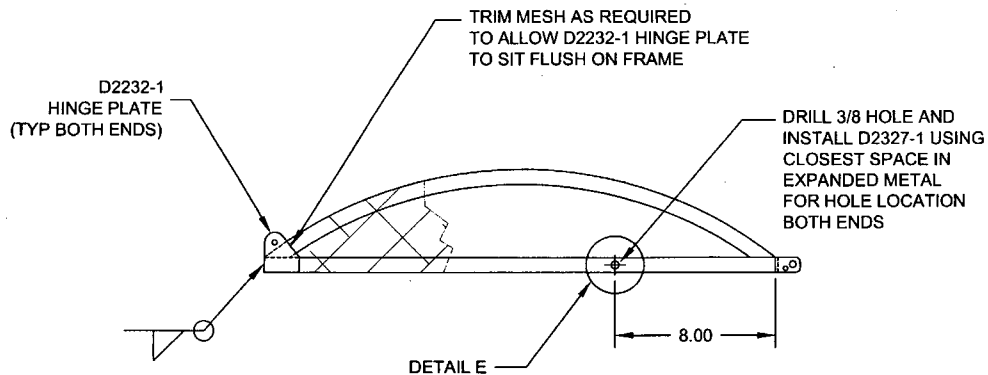
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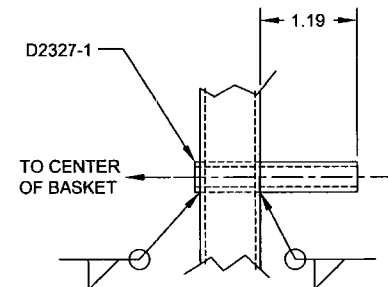
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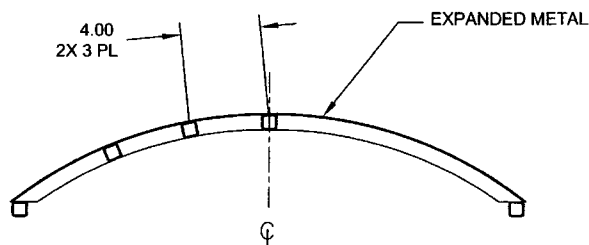
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2







DETAIL E C6-4



SECTION D-D SAME BOTH CENTER RIBS A4-2

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08-06-17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

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